



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB910-0020
Job Sheet 194905



Part No: RB910-0020

Job Qty: 2 pcs

Part Name: Drain Hose



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/9/19

Job Tracking No:

Due Date: 7/11/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: IPP Rev A 17.11.08 New issue DP Verify DD

Ship Via:

Order 16291 E
16285

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
110	Small Fab - 1	2 pcs	7/11/19		0.00	2.00	Small Fab - 1	
							Small Fab - 2	MLL
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
120	QC 5	2 pcs	7/11/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
130	Packaging 3-1 - Stock - B4B	2 pcs	7/11/19		0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	
							Packaging 3 - 10 - B4B	
							Packaging 3 - 11 - B4B	
							Packaging 3 - 12 - B4B	
							Packaging 3 - 13 - B4B	
							Packaging 3 - 14 - B4B	
							Packaging 3 - 15 - B4B	
							Packaging 3 - 16 - B4B	
							Packaging 3 - 17 - B4B	
							Packaging 3 - 18 - B4B	



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CANADA
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Container No: S193778



Part: RB910-0020

Job No: 194905

Serial No/Batch: S193778

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 06/25/19

DAS
JUN 25 2019 40
9-89

DAS
28
9-89

					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	2 pcs	7/11/19	0.00 0.00	QC 21 - SA - 21	JUN 26 2019	
				QC 21 - SA - 70		
				QC 21 - SA - 53		

Part Op 110 - (Small Fab) - Assemble as per DWG. Sheet 1 Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one end of the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable).

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2044T46	Tube Ø0.93	.7600 ft (.38 ea)	110-Small Fab - 1	3016489
2044T66	Cap Ø0.93	4 Ea (2 ea)	110-Small Fab - 1	3009693
51495K116	COUPLING 1/2" NCKL PLTD BRASS	2 Ea (1 ea)	110-Small Fab - 1	3129663
9263K642	O-Ring	2 Ea (1 ea)	110-Small Fab - 1	3189713
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	12 ft (6 ea)	110-Small Fab - 1	3190980
M304TR0.375W.065	304 Round Tube .375 X .065W	.1660 ft (.083 ea)	110-Small Fab - 1	3145223
PAD210	Foam Ø1 X 1 replace item 1887T48	.0140 sf (.007 ea)	110-Small Fab - 1	3021250
RB910-0020-1	Quill	2 pcs (1 ea)	110-Small Fab - 1	3190126

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	2044T46	1	8	0
	2044T66	4	48	0
	51495K116	2	71	0
	9263K642	2	48	0
	K010-0608	12	527	0
	M304TR0.375W.065	0	31	0
	PAD210	0	1	0
	RB910-0020-1	2	0	0

Part Specifications

Specifications could not be found.

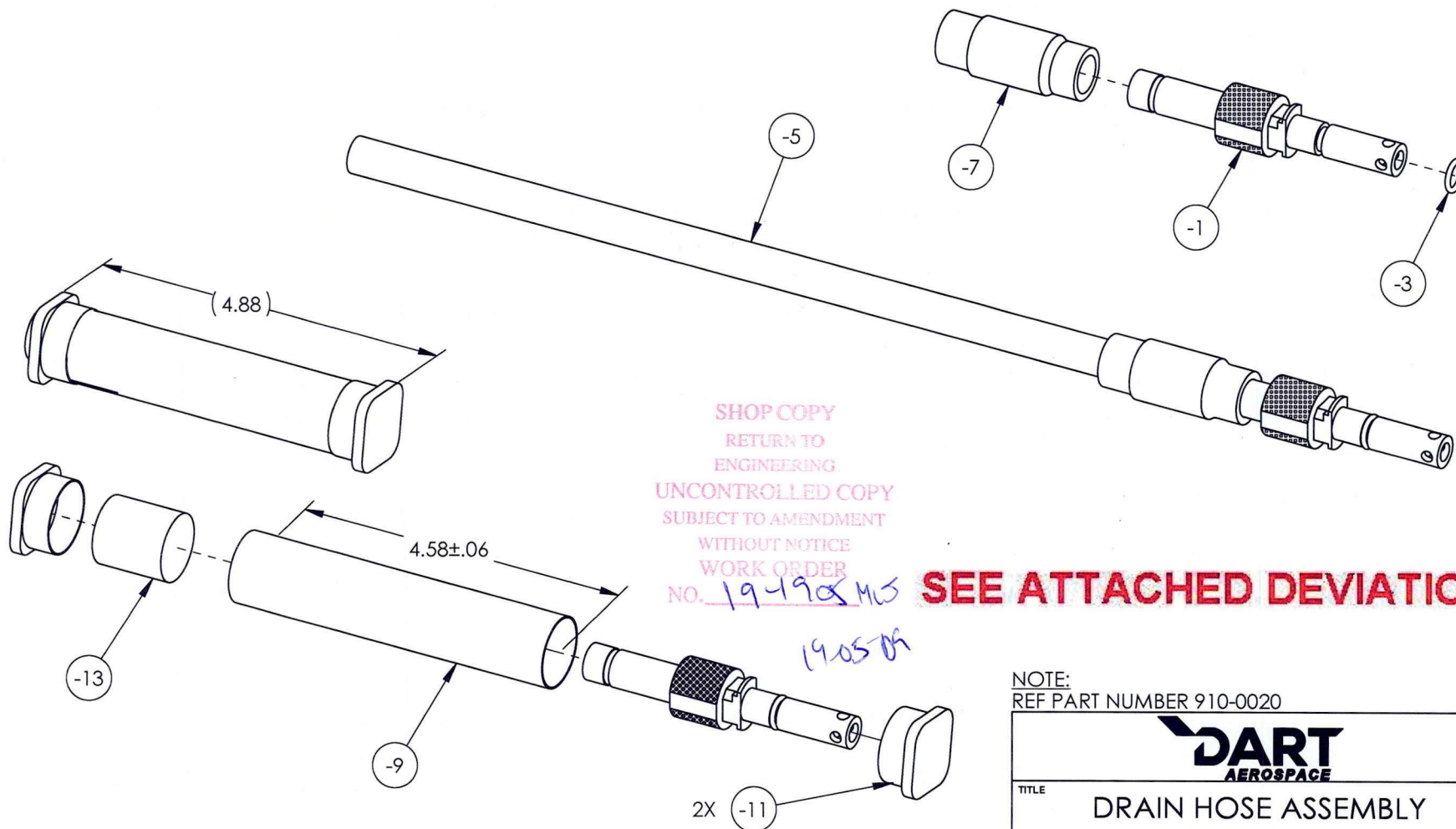
Plex 5/9/19 4:40 PM Dart.Renwick.Jennifer

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
2	16-0078	-9 CH'D DIM WAS 4.68± .06 IS 4.58 ± .06. -11 CH'D DIM WAS (4.98) IS (4.88) -13 CH'D MAT'L WAS LINT FREE SPONGE IS POLYESTER/POLYURETHANE.			7/15/2016	DEW	SM



NOTE:
REF PART NUMBER 910-0020

DART AEROSPACE																											
TITLE DRAIN HOSE ASSEMBLY																											
DWG NO. RB910-0020	REV 2																										
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ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	FITTING	6061	Ø7/8 X 3-1/4	2
		B/O	-3	1	O-RING	VITON	2-011N70 OR MCMASTER-CARR #9263K642	1
		B/O	-5	1	HOSE	VINYL	Ø1/2 OD X Ø3/8 ID X 6 FT KURI-TECH #K010-0608	1
		B/O	-7	1	COUPLING	NICKEL-PLATED BRASS	Ø1/2 MCMASTER-CARR #51495K116	1
		B/O	-9	1	TUBE	POLYETHYLENE	Ø.93 MCMASTER-CARR #2044T46	1
		B/O	-11	2	CAP	VINYL	Ø.93 MCMASTER-CARR #2044T66	1
		B/O	-13	1	SPONGE	POLYESTER/POLYURETHANE	Ø.93 x 1 NEW PIG CORP #PAD210	1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. <u>RB910-0020 Rev. 2</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Eng. (Non-AW) ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier ☐</td> </tr> <tr> <td></td> <td></td> <td></td> <td>Quality ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐				Quality ☐																												
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Kuri-Tech Hose (K010-0608) easily pulls out of Coupling (McMaster Carr 51495K116)		Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one end of the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable). This deviation is acceptable. The fit, form and function of the part will be as originally intended.		Completed By 																																													
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